

# Work Order ID 82049

**\*82049\***

Page 1

March-22-12 10:34:56 AM

Item ID: D2571 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Fwd Out 205  
 Start Date: 22/03/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 05/04/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	Rev E								

100 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*100\***  
 HAAS I  
 HAAS CNC vertical machine #1  
 Memo  
 Program Batch No. 82049 Double check by: [Signature] 1-Machine Step No 1  
 per Folio FA051 and inspect per attached Dimension Sheets2-Machine Step  
 No 2 per Folio FA051 and inspect per attached Dimension Sheets3-Machine  
 Step No 3 per Folio FA051 and inspect  
8 / 8 120402 (8)

110 CONVENTIONAL MILLING MACHINE 0.00  
**\*110\***  
 Mill Conv  
 Conventional Milling Machine  
 Memo  
 Machine keyway as per dwg D2571 & D2572  
8 0 8  
 12/04/04

120 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*120\***  
 QC  
 Quality Control  
 Memo  
8 0 8  
 12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82049

**\*82049\***

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March-22-12 10:34:56 AM

Item ID: D2571 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Fwd Out 205  
 Start Date: 22/03/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 05/04/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10h20 10h50 FINISH TIME: 320°C								

8x8 M/L 12/04/04

8 & (2P) 12/04/05

m120222.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82049

**\*82049\***

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March-22-12 10:34:56 AM

Item ID: D2571 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Fwd Out 205  
 Start Date: 22/03/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 05/04/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00

**\*160\***

QC Memo 0.00

Quality Control

*S 12-4-9*

170 Identify as per dwg & Stock Location *ST 432* 0.00

**\*170\***

Packaging Memo 0.00

Packaging

*Sx* *SP 12-04-10*

180 QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC Memo 0.00

Quality Control

*12/4/10*

*12-04-10*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-22-12 10:34:59 AM

Page 1

Work Order ID: 82049

\*82049\*

Parent Item: D2571

\*D2571\*

Parent Item Name: Saddle, Fwd Out 205

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated  
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	53.0000	1	8			

\*D6101-007\*

Saddle Billet

\*\*

86 12103129

Location

Loc Qty

Loc Code

MAT042

48

79589

20

79875

28

MAT045

5

70680

3

76839

2

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



05.12.2014

12/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 82049
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.749	1.750	1.750		
C	3.495	3.505		3.499	3.499	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		8.002	8.003	8.002	8.003		
F	0.490	0.510		.506	.493	.503	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.502	.498	.501	.505		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.565	.559	.568	.571		
L	1.174	1.184		1.176	1.179	1.180	1.180		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.501	2.502	2.500		
O	3.869	3.879		3.870	3.873	3.872	3.872		
P	0.115	0.135		.125	.125	.126	.124		
Q	0.115	0.135		.128	.130	.128	.130		
R	0.240	0.260		.246	.247	.248	.248		
S	0.115	0.135		.127	.123	.132	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.958	2.958		
V	0.230	0.250		.235	.236	.234	.237		
W	0.115	0.135		.120	.122	.119	.118		
X	0.308	0.313		.303	.310	.310	.310		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.363	.365	.365	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.623	.623	.624		
AC	0.053	0.073		.063	.083	.063	.063		
AD	0.240	0.260		.247	.240	.247	.245		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.124	.133	.128	.128		
AG	0.240	0.280		.247	.247	.249	.250		
AH	0.240	0.260		.245	.245	.244	.244		
AI	2.000	2.020		2.004	2.004	2.005	2.008		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by:	KRB
Date:	12 04 02

Audited by:	B.A
Date:	12/04/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82049
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>	

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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.5	3.5		
D	1.745	1.755		1.750	1.750	1.75	1.75		
E	7.990	8.010		8.003	8.003	8.006	8.003		
F	0.490	0.510		.497	.498	.507	.504		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.503	.502	.504	.504		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.567	.569		
L	1.174	1.184		1.178	1.179	1.178	1.178		
M	1.490	1.500		1.496	1.495	1.494	1.495		
N	2.495	2.505		2.5	2.5	2.501	2.500		
O	3.869	3.879		3.872	3.873	3.872	3.873		
P	0.115	0.135		.124	.124	.124	.125		
Q	0.115	0.135		.130	.130	.128	.128		
R	0.240	0.260		.246	.248	.248	.247		
S	0.115	0.135		.134	.128	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.96	2.96	2.96	2.96		
V	0.230	0.250		.238	.238	.235	.240		
W	0.115	0.135		.120	.116	.120	.118		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.365	.362	.369	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.623	.623	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.246	.245	.245		
AE	1.375	1.395		1.387	1.389	1.391	1.387		
AF	0.115	0.135		.132	.130	.130	.130		
AG	0.240	0.280		.254	.255	.254	.255		
AH	0.240	0.260		.250	.250	.243	.245		
AI	2.000	2.020		2.003	2.004	2.006	2.004		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by:	7/12-04-02
Date:	

Audited by:	B.A
Date:	12/04/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	